

Work Order ID 51126

August 4, 2009 11:05:24 AM

Page 1

Item ID: D2327-3

Accept

Revision ID: D

Item Name: Spacer Bushing

Start Date: 8/14/09 Start Qty: 10.00

Required Date: 8/21/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-08-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2327

Rev D

100

0.00



Hardinge CNC LATHE SMALL

0.00

Hardinge

Memo

Hardinge CNC Lathe Small

Turn per Folio FA232 and Dwg D2327 11Deburr

SA 09/08/31

10 6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

SA 09/08/31

10 6

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

SA 09/08/31

10 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51126

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Page 2

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location Steve

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

9/8/31 102SP

09/09/01 H

PL 09-8-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

August 4, 2009 11:05:23 AM

Work Order ID: 51126

Parent Item: D2327-3RevD

Parent Item Name: Spacer Bushing


Comments:

Start Date: 8/14/09

Required Date: 8/21/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	13.2932	1.6453			
												
304 ROUND BAR 0.375												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT 13.29317895

110166 3.32

110472 6.41

112058 * 3.56317895

112473



1.6 AT 8 Nov 08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order:	5126
Description: Spacer Bushing		Part Number:	D2327-3
Inspection Dwg: D2327 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

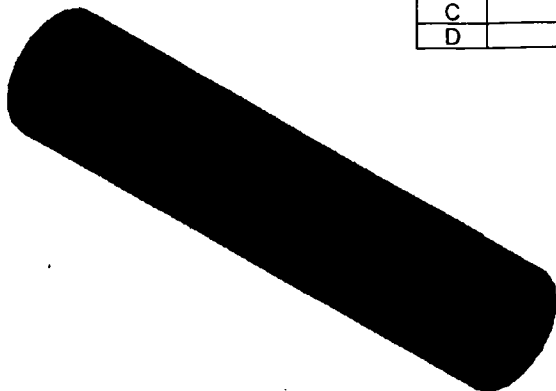
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	.374	/			
Ø0.257	+0.005/-0.000	.258	/			
1.750	+/-0.010	1.752	/			

Measured by:  Date: 09/08/31	Audited by: M. A Date: 09/08/31	Prototype Approval: N/A Date: N/A
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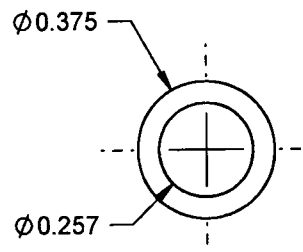
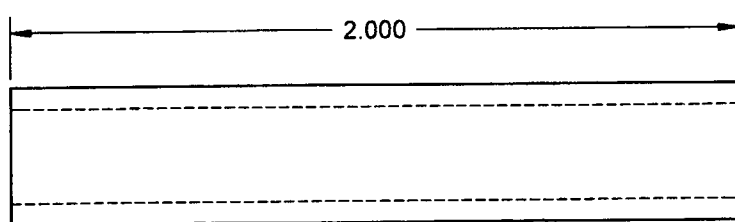
Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	



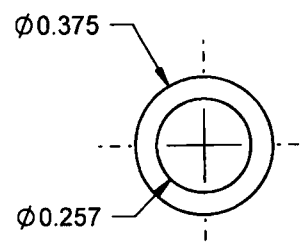
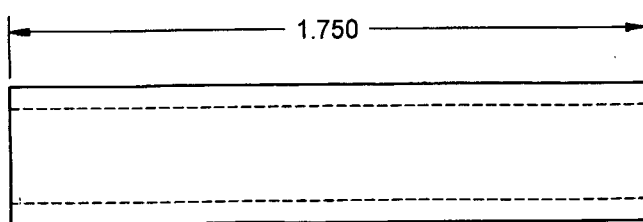
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED CH	DRAWING NO. D2327
DATE 06.10.12		REV. D SHEET 1 OF 1
TITLE SPACER BUSHING		SCALE 2:1
REV	DATE	DESCRIPTION
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED
D	06.10.12	REMOVE 303 SS MATERIAL



51126
MF
09-08-04
RELEASED
06.11.14



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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